

Date: Thursday, 12/20/2007 3:25:21 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 36499		
Estimate Number	: 12577		
P.O. Number	:	Part Number	: D3562042
This Issue	: 12/20/2007 S.O. No. :	Drawing Number	: D3562 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 35822	Material	:
Written By	:	Due Date	: 1/30/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>071221</u>		
Comment	: Est Rev:A New Issue 06-11-09 JLM		
	: Est rev B ECN 987 07.10.09 EC verified by: DD		
	: Est Rev:C ECN1048 07-12-18 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>B35618</u>

Check Material for any Dents or Defects

SAD 08:01:31 (5)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 08:01:31 5

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08:01:31 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 36499

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PK 08.02.06 5

6.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

Batch: *335296*

PK 08.02.06 5

7.0

D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

Batch: *335298*

PK 08.02.06 5

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 160.0000 Each(s)

Blind Rivet

batch: ~~335298~~ *11106431*

PK 08.02.06 5

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: *106695*

PK 08.02.06 5
PK 08.02.06 5
PK 08.02.06 5

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/07 48042

11.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty/Part Number


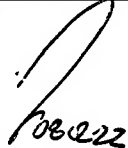

Description Batch

2 D2734

End Cap *D36520*

PK 08.02.19 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-02-21	8.0	On Step 8, MS20600 AD4WS (blind Rivet) the total is suppose to be 160 total rivet used not 180. change Quantity of total rivets and per unit to 32		08/02/21			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36499

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

2-Grind end cap welds flush as per Dwg D3562

SAV 08-02-20 5

SAV 08/02/21 (5)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-02-21 (5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-02-22 (5)

(P-10)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005 touch up alodine -

FL 08/02/22 (5)

HL 08-02-25 (X5)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005.4.4

Batch: M106874

FL 08/02/25 (5)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 08-02-26 (5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

See WRO 36498

7 08-02-26 (5)

SL (5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-042 PAR #: NA Fault Category: Prod / FAB. ASS. / Large NCR: Yes No DQA: LD Date: 08/02/26
 QA: N/C Closed: HJ Date: 08/02/26

NCR: <u>36499</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080222	14.0	1 step was found to have a tiny burr on hole. Re: loose piece of magnet.	<u>[Signature]</u>	Drill a hole as necessary to remove object. Fill hole with weld per Q81004, and grind flush.	<u>[Signature]</u> 08-02-22	<u>[Signature]</u> 08-02-22	<u>[Signature]</u>	<u>[Signature]</u> 08-02-22

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 36499

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



5

Comment: FINAL INSPECTION/W/O RELEASE

2008/12/26

Job Completion



2008/12/26 5

Dart Aerospace Ltd

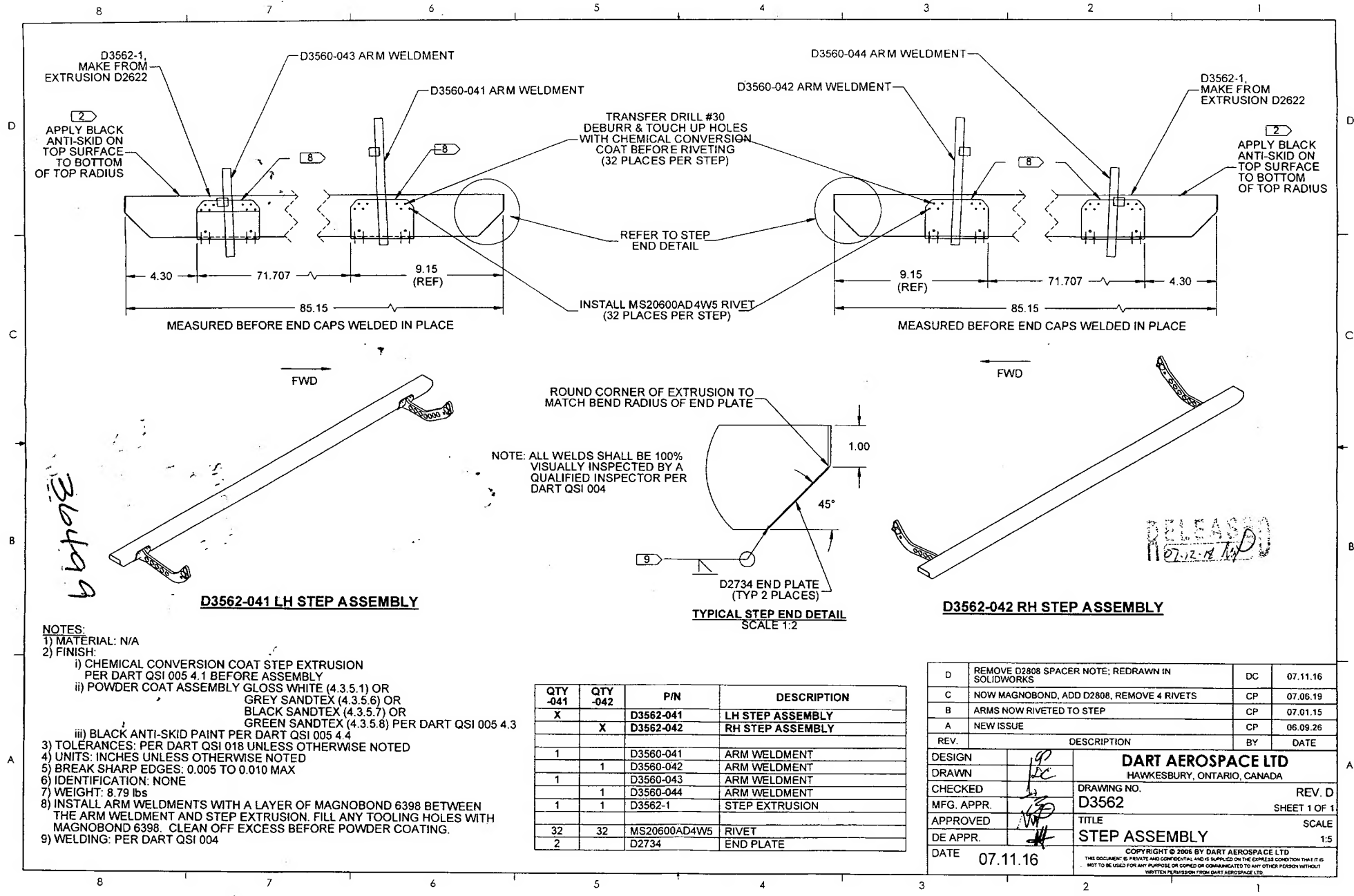
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 8.79 lbs
 - 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
 - 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
1		D3562-1	STEP EXTRUSION
32	32	MS20600AD4W5	RIVET
2		D2734	END PLATE

D	REMOVE D2808 SPACER NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3562

TITLE
STEP ASSEMBLY

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REV. D
SHEET 1 OF 1
SCALE
1:5